

Work Order ID 65100

Thursday, January 06, 2011 10:42:57 AM



Page 1

Item ID: D3572-5	Accept		Setup Start	
Revision ID:			Stop	
Item Name: Bracket				
Start Date: 1/6/2011	Start Qty: 12.00		Cust Item ID:	
Required Date: 1/13/2011	Req'd Qty: 12.00		Customer:	
Reference:				

Approvals:	Process Plan: <u>PL</u>	Date: <u>11-01-11</u>	Tooling:	Date:	Run Start	
	QC:	Date:	SPC (Y/N):	Date:	Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3572	Rev D								

100		0.00							
	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D3572 <input type="checkbox"/> Dwg Rev: <u>D</u> <input type="checkbox"/> Prog Rev: <u>D</u> <input type="checkbox"/> 2-								
6061 .080	Deburr if necessary								

110		0.00							
	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

120		0.00							
	QC8- Inspect parts - second check								
QC	Memo	0.00							
Quality Control									

HB11-1-11

(12)

HB11-1-11

(x12)

8/1/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Work Order ID 65100

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Page 2

Item ID: D3572-5

Accept



Setup Start



Revision ID:

Item Name: Bracket

Stop



Start Date: 1/6/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 1/13/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130



Brake NC

NC BRAKE

0.00

Memo

0.00

Brake NC

form bend as per Dwg D3572 usin DT8943

7 m-l

11/01/13

12x

140



QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Quality Control

Sula 13

12

150



Packaging

Identify as per dwg & Stock Location: ERIC L

0.00

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****



Eric L 12

W/O:		WORK ORDER CHANGES					
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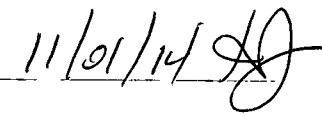
Page 3

Thursday, January 06, 2011 10:42:57 AM

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Revision ID:
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Required Date: 1/13/2011 Req'd Qty: 12.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC	QC21- Final Inspection - Work Order Release	0.00							
Quality Control	Memo	0.00							

11/01/14 
u u.01.14

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Thursday, January 06, 2011 10:43:01 AM

Page 1

Work Order ID: 65100

Parent Item: D3572-5

Parent Item Name: Bracket



Start Date: 1/6/2011

Required Date: 1/13/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev :A New Issue 07-01-16 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6S.080

Purchased

No

sf

164.4000

0.03

0.360180



6061-T6 .080 Sheet



151-1-11

Location

Loc Qty

Loc Code

MAT

164.4

116268

164.4

116268

(12)

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 45100
PH-01-U

RELEASED
09-04-28

D3572-041 GUIDE ASSEMBLY

D3572-043 GUIDE ASSEMBLY (UH-1)

D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.05; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<u>LE</u>	DRAWING NO.	REV. D
MFG. APPR.	<u>LE</u>	D3572	SHEET 1 OF 4
APPROVED	<u>LE</u>	TITLE	SCALE
DE APPR.	<u>LE</u>	GUIDE ASSEMBLY	NTS
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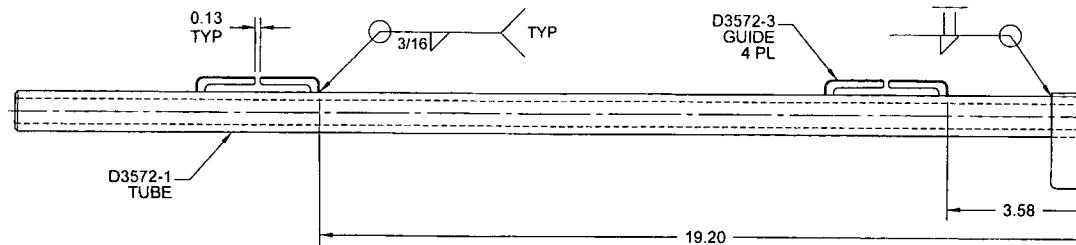
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

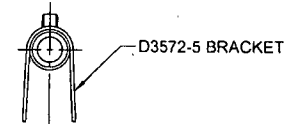
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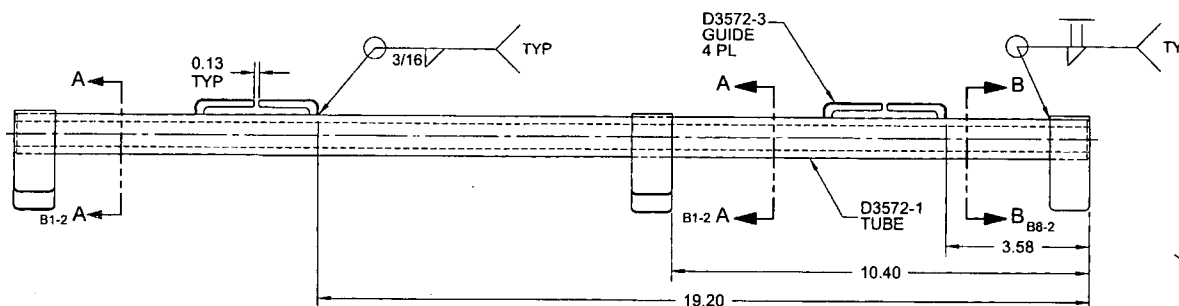
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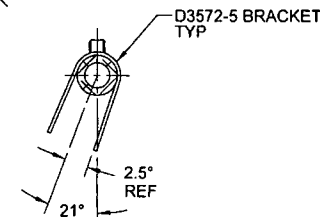
D3572-041 GUIDE ASSEMBLY



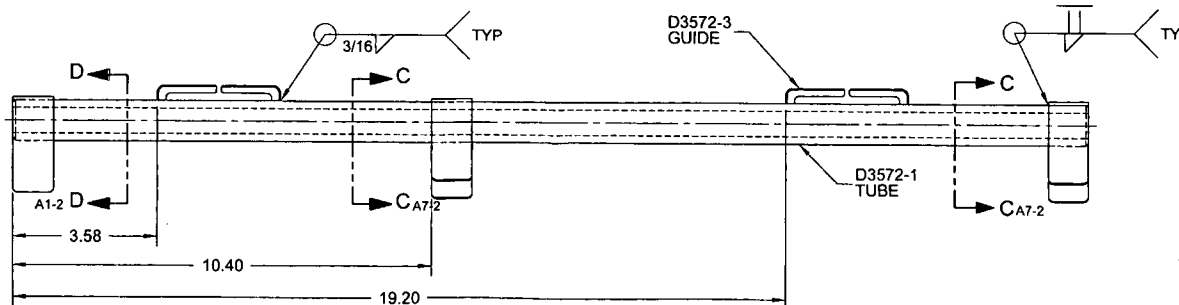
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D3572-043 GUIDE ASSEMBLY

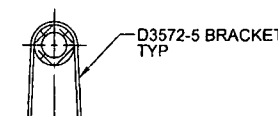


**SECTION A-A C7-2
(2 PL) C4-2**



D3572-044 GUIDE ASSEMBLY





RELEASED
09.04.17



SECTION D-D A7-2

SECTION B-B C2-2

**SECTION C-C A2-2
A5-2**

DESIGN	LE	DART AEROSPACE LTD	
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MFG. APPR.		D3572	SHEET 2 OF 4
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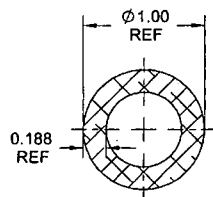
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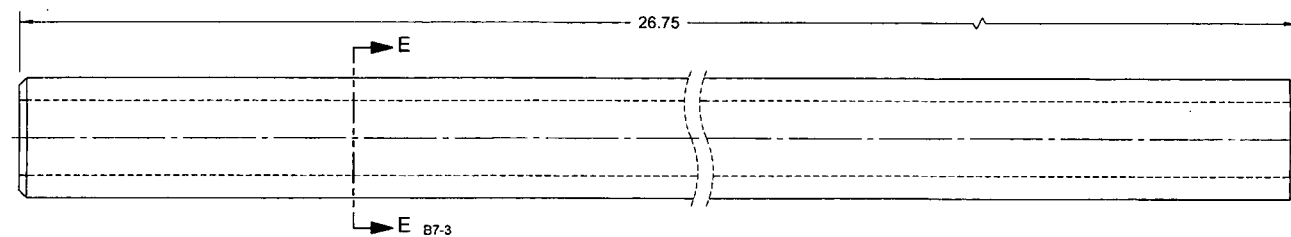
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NOTE: Date & initial all entries

01045100



SECTION E-E C5-3



D3572-1 TUBE

RELEASED
09/04/17 MP

- D3572-1 NOTES:**
- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.25 lbs

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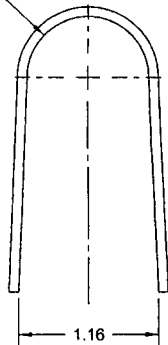
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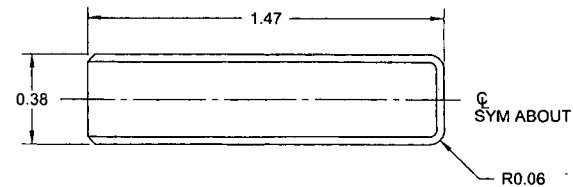
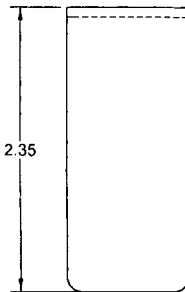
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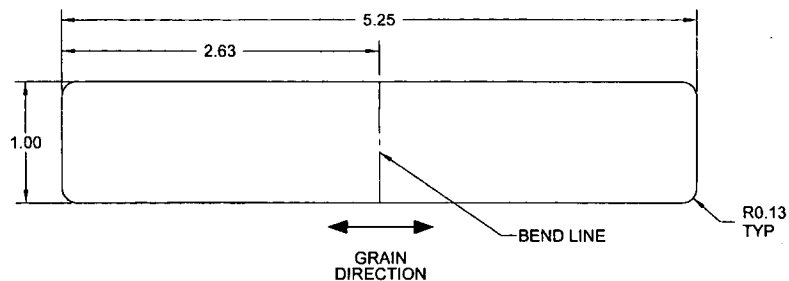


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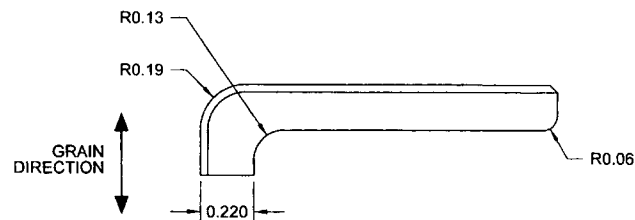


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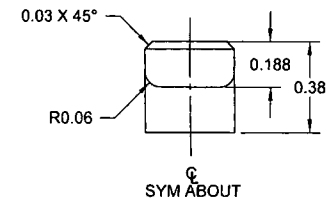
D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-5F FLAT PATTERN



D3572-3 GUIDE



RELEASED
9/04/17

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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